

Work Order ID 132224

May-04-15 11:47:29 AM

Report

132224

Page 1

Item ID: D3650-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle
 Start Date: 5/04/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 5/04/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3650	Rev E								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3650Dwg Rev: E Prog Rev: E 2-Deburr
 if necessary

(5) _____ 05/05/04

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

(5) _____ 05/05/04

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

(5) _____ 05/05/04

DAS
38
9-89
MAY 05 2015

Work Order ID 132224

May-04-15 11:47:29 AM

132224

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00			DAS 30 9-89	5			MAY 05 2015
130	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3650								
140		0.00							DAS 38 9-89
140	QC5- Inspect part completeness to step on W/O					5			MAY 05 2015
QC	Memo	0.00							
Quality Control									
150		0.00			DAS 30 9-89	5			MAY 05 2015
150	Identify as per dwg & Stock Location: GA								
Packaging	Memo	0.00							
Packaging	LOCATION : GA								

Work Order ID 132224

132224

Page 3

May-04-15 11:47:29 AM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							MAY 05 2015
160									
QC	Memo	0.00							
Quality Control									

MLS MAY 05 2015

Picklist Print

May-04-15 11:47:28 AM

Page 1

Work Order ID: 132224

132224

Parent Item: D3650-9

D3650-9

Parent Item Name: Angle

Start Date: 5/04/15

Required Date: 5/04/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No			110	sf	74.6567	0.051	1			

M304S26GA

304/316 0.018 SHEET

2615/05/04

Location

Loc Qty

Loc Code

MAT020

74.6567

m130650

74.6567

36

DART AEROSPACE LTD		Work Order:	132204
Description: Angle		Part Number:	D3650-9
Inspection Dwg: D3650	Rev: E	Page 1 of 1	

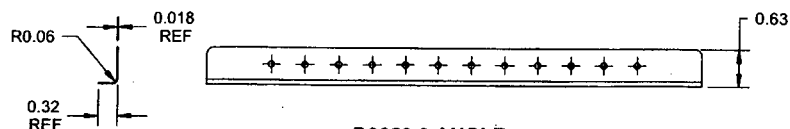
INSPECTION SHEET

[illegible]

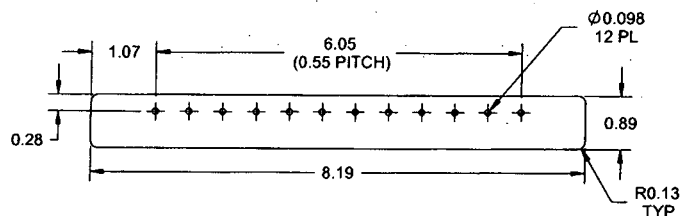
Measured by:	DC	Checked by:	38 9-89	QC Inspector:	
Date:	15/05/09	Date:	MAY 05 2015	Date:	

Engineering Approval: (If necessary)		Date:	
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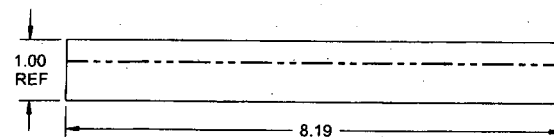
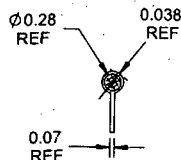
Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	
B	12.09.26	Dwg Rev updated	KJ	
C	15.04.24	Dwg Rev updated	KJ	



D3650-9 ANGLE
(MAKE FROM D3650-9F)



D3650-9F ANGLE (FLAT PATTERN)



D3650-7-8.19 SEAL

- NOTES:**
- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.05 lb
 - 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

W/O 132724

RELEASE
2012-10-09

- D3650-9F**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S26GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.05 lb

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3650	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	12.10.01	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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